



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4110-1
Job Sheet 180814



Part No: D4110-1

Job Qty: 6 ea

Part Name: Door Doubler, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Due Date: 7/20/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A SHEET 2 IPP Rev:A 10.09.24 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Waterjet		SC 180717
100	Waterjet	6 pcs	7/20/18	7/20/18	0.00	0.37	Waterjet1		SC 180717
110	QC	6 pcs	7/20/18	7/20/18	0.00	0.00	QC2 Waterjet-3		SC 180717
120	QC	6 pcs	7/20/18	7/20/18	0.00	0.00	QC8-4		SC 180717
130	Small Fab	6 pcs	7/20/18	7/20/18	0.00	0.77	Small Fab-5		SC 180717
140	QC	6 pcs	7/20/18	7/20/18	0.00	0.00	QC5		SC 180717
150	Packaging	6 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3	54078	JUL 18 2018
160	QC21-SA	6 Ea	7/20/18	7/20/18	0.00	0.00	QC21		JUL 18 2018

Part Op 100 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary
Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
130 - 1- C'sink holes as per dwg
140 - QC5- Inspect part completeness to step on W/O
150 - Identify as per dwg & Stock Location:
160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.1908 sf (.0318 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	0	150	0

Part Specifications

Specifications could not be found.

Plex 7/17/18 8:10 AM dart.lacelle.linda



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Container No: S092812



Part: D4110-1

Job No: 180814

Serial No/Batch: S092812

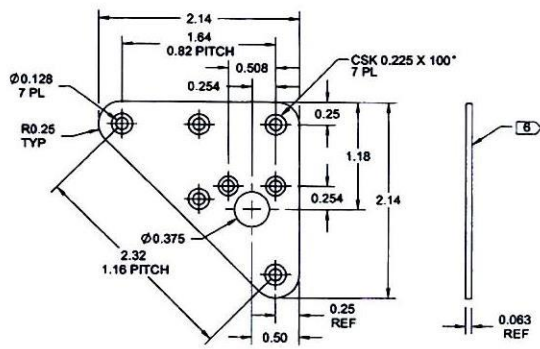
Revision:

Inspector:

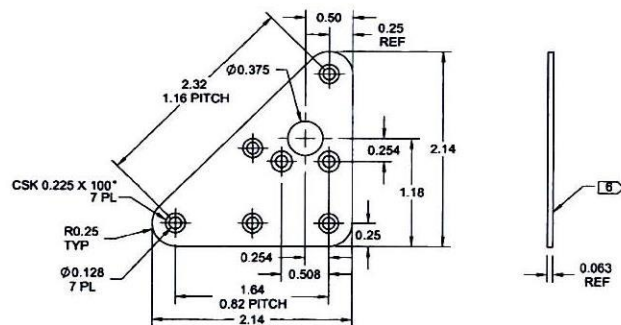
Exp Date:

Instructions:

Date: 07/17/18



D4110-1 DOUBLER, LH DOOR



D4110-2 DOUBLER, RH DOOR

RELEASED
2010-09-23

NOTES:

- 1) MATERIAL -1 & -2: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4110-X & B/N PER QSI 044 6.1
- 7) WEIGHT -1 & -2: 0.05 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO. D4110	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		DOUBLER	SCALE
DE APPR.			NTS
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD	